

Work Order ID 52529

September 29, 2009 11:32:02 AM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID: F3

Stop



Item Name: 206 (24") Bearpaw

Start Date: 29/09/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 09-9-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

13 9-10-13

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

H.A 09/10/16

10

0

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

H.A 09/10/16

10

0

10

Picklist Print

September 29, 2009 11:32:01 AM

Page 1

Work Order ID: 52529

Parent Item: D2432RevF3

Parent Item Name: 206 (24") Bearpaw



Start Date: 29/09/2009

Required Date: 16/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	523.2231	37.0000	44.4		
UHMW 1" Black												

B 9-10-13

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	446.5752	
112186	126.5752	
112514	200	112514
112681	120	
Main Warehouse		
ST	76.6479	
108762	11	
109186	5	
110520	8	
110721	10.5602	
111354	42.0877	

DART AEROSPACE LTD		Work Order:	52529
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.067 x 45°	✓			
B	5.500	+/-0.030	5.500	✓			
C	0.200	+/-0.030	0.199	✓			
D	0.25 x 45°	+/-0.030	0.256 x 45°	✓			
E	R0.250	+/-0.030	R0.250	✓			
F	0.250	+/-0.010	0.247	✓			
G	0.625	+/-0.030	0.616	✓			
H	0.375	+/-0.010	0.373	✓			
I	0.950	+0.030/0.010	0.956	✓			
J	19.000	+/-0.030	19.000	✓			
K	3.14	+/-0.030	3.141	✓			
L	3.28	+/-0.030	3.300	✓			
M	Ø0.260	+0.005/-0.000	Ø0.260	✓			
N	Ø0.93	+/-0.030	Ø0.926	✓			
O	0.30	+0.030/-0.000	0.305	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.254	✓			
S	2.000	+/-0.030	2.001	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	8.998	✓			
V	0.375	+/-0.010	0.377	✓			

Measured by: H.A. Date: 09/10/16	Audited by: [Signature] Date: 09/10/16	Prototype Approval: N/A Date:
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Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF [Signature]	[Signature]

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WITH
WORK ORDER

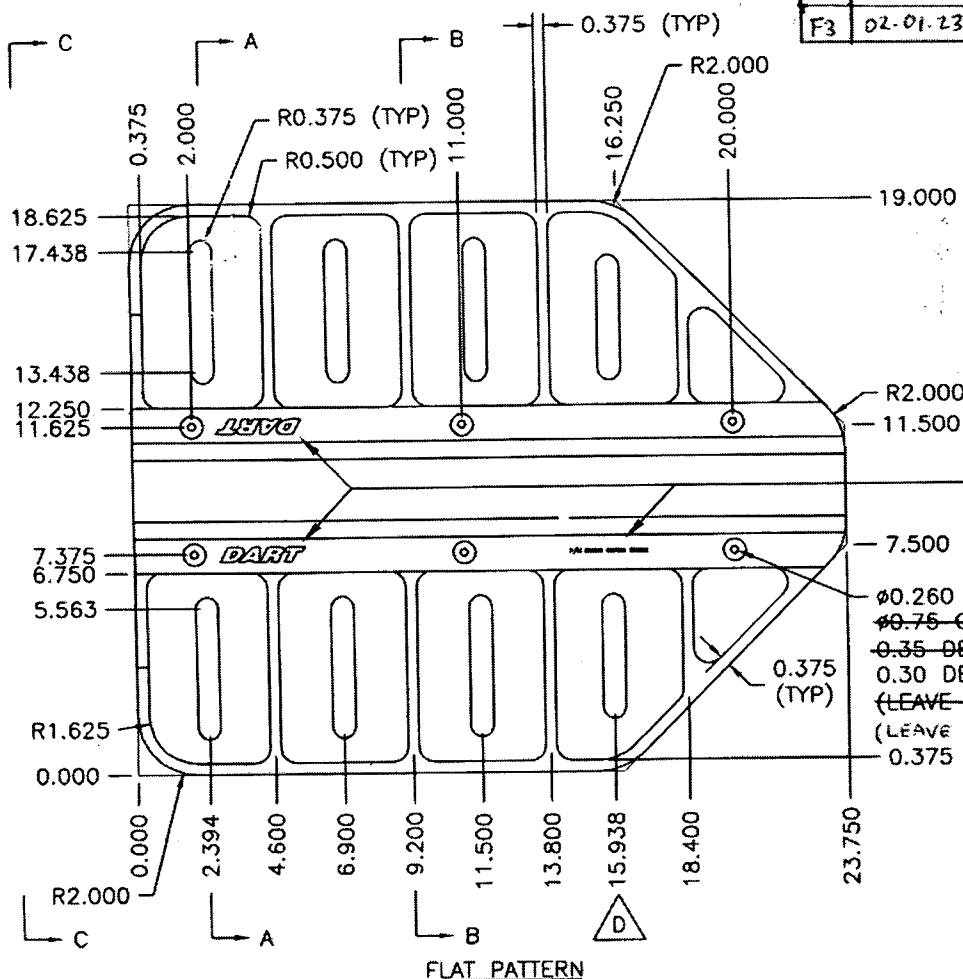


NO. 52529-14 04-9-95

RELEASED
98.06.17 KE

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02-01-23	CLARIFY BORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.93 C'BORE
~~0.35 DEEP FROM TOP (MIN.)~~
0.30 DEEP FROM BOTTOM
~~(LEAVE 0.300 MIN.)~~
0.375
(LEAVE 0.650 MIN.)



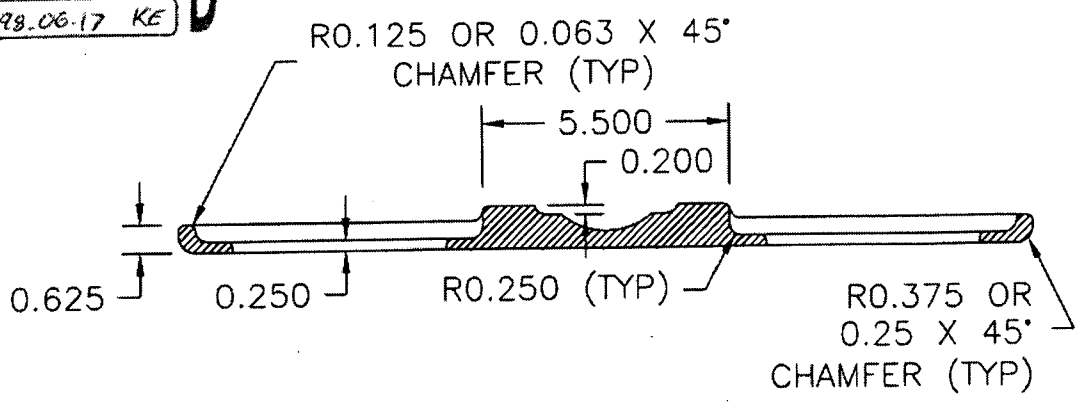
EFFECTIVE	DEOS
9143	

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	KE	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N
		SCALE 1:6

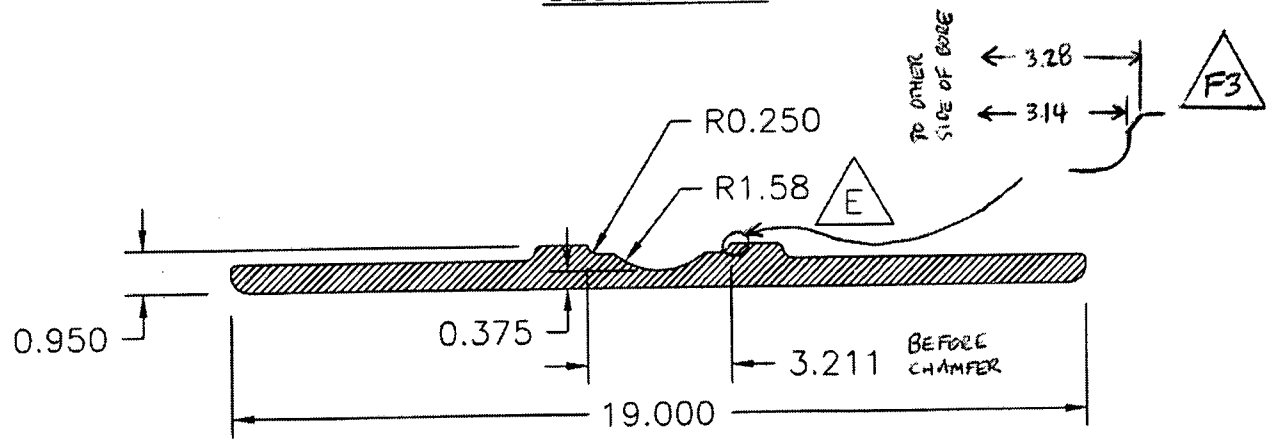


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

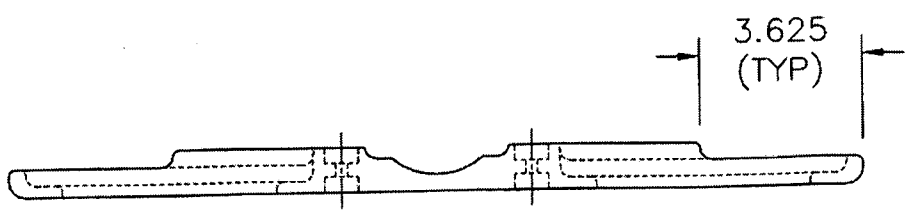
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

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NO. 52529